Sunday, 12/4/2005 12:47:03 PM

User:

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 25093A

: 10209

P.O. Number

Prsht Rev.

First Issue

:N/A

This Issue

Previous Run

: 12/4/2005

: NC

S.O. No. : NIA

: NIA

Type

: LARGE FAB ASSY

: 23714A

Written By **Checked & Approved By**

Comment

: Est Rev:C

Re-Format

05-11-03 JLM

Drawing Name

: 350 BASKET BASE (SHORT)

Part Number

: D3265041

Drawing Number

- D3265 REV B

Project Number

: N/A

Drawing Revision Material

:NIA

Due Date

: 1/20/2006

Qty:

1 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D31661

Comment: Qty.: Qty 3 D3166-1 Basket Hoop Batch:

3.0000 Each(s)/Unit Total:

3,0000 Each(s) 25896

Basket Hoop

M304TS0750W065 2.0

304 SQ Tube.75x.75x.065W



Comment: Qty.: 19.2150 f(s)/Unit Total: 19.2150 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SS tubing.

(M304TS0.750W.065) Batch: MIOIII D22323

Basket Hinge



2.0000 Each(s)/Unit Total:



Comment: Qty.:

Pick:

Batch

2 D2232-3

Qty Part Number

Hinge bracket

Description

2.0000 Each(s)

D2325

Support Gusset (350 Bask

B) 06/06/05

4.0

3.0

Comment: Qty.: 4.0000 Each(s)/Unit Total:

4.0000 Each(s)

Pick:

4 D2325

Qty Part Number

Description

Support Gusset 🖒

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M06/06/06

W/O:					W	ORK ORDER CH	HANGES					
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DATE					Initial Chief Eng	Corrective Action Action Descri	Section B ption	Sign 8	Verifica		Approval Chief Eng	Approva QC Inspect

NOTE: Date & initial all entries

Date: Sunday, 12/4/2005 12:47:03 PM User: Linda Lacelle **Process Sheet** Drawing Name: 350 BASKET BASE (SHORT) Customer: CU-DAR001 Dart Helicopters Services Job Number: 25093A Part Number: D3265041 Job Number: Description: Seq. #: Machine Or Operation: Spacer Bushing 5.0 D23273 2.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: Description **Qty Part Number** M 06/06/06 2 D2327-3 Bushing 6.0 D2581 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: M 6/6/6 Description **Qty Part Number** Mounting Bracket 826204 2 D2581 7.0 D34425 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Description **Qty Part Number** B24246 2 D3442-5 Shim 8.0 M304EX07516F Expanded Metal Flat Stai 26.0000 sf(s)/Unit Total: 26.0000 sf(s) Comment: Qty.: Pick: Part Number Description Batch Qty 26sf M304EX0.75-16F Expanded Metal M100981

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



1-CUT (3) D2235-1 FROM D3166-1

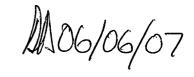
Comment: LARGE FABRICATION RESOURCE 1

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required





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NOTE: Date & initial all entries

Date: Sunday, 12/4/2005 12:47:03 PM User: Linda Lacelle **Process Sheet** Drawing Name: 350 BASKET BASE (SHORT) Customer: CU-DAR001 Dart Helicopters Services Part Number: D3265041 Job Number: 25093A Job Number: Seq. #: Machine Or Operation: Description: PD 06-06-07 DDIMENSIONAL & WELDING INSPECTION 10.0 QC9/6 Comment: DDIMENSIONAL & WELDING INSPECTION 11.0 POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 HAND FINISHING RESOURCE #1 12.0 HAND FINISHING Comment: HAND FINISHING RESOURCE #1 06/06/23 Seal support gusset seam with White Sikaflex-291 Batch: MIOII Expiry date: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 13.0 COAT/CHEMICAL CONVERSION Inspection level Job Completion

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Description Machine or Operation Seq. No. 4.0000 Each(s) 4.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Assemby Kit Qty Part Number Description Batch AN970-4 Washer MS20600AD4W3 Cherry Rivets 23.0 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: Pick: Assemby Kit Qty Part Number Description Batch MS20600AD4W3 Rivet MS21042L3 Nut 24.0 Comment: 2.0000 Each(s)/Unit Total: Qty.: Pick: Assemby Kit Qty Part Number Description Batch MS21042L3 Nut (or -3) MS21042L4 25.0 Nut Comment 4.0000 Each(s)/Unit Total: Pick: Assemby Kit Qty Part Number Description Batch MS21042L4 Nut (or -4) MS21042L5 Nut 26.0 Total: 4.0000 Each(s) 4.0000 Each(s)/Unit Comment: Pick: Assemby Kit **Qty Part Number** Description Batch MS21042L5 Nut (or -5) SMALL & MEDIUM FABRICATION RESOURCE 2 27.0 SMALL FAB 2 **SMALL & MEDIUM FABRICATION RESOURCE 2** Comment INSPECT WORK TO CURRENT STEP 28.0 QC5 INSPECT WORK TO CURRENT STEP Comment: PACKAGING RESOURCE #1 PACKAGING 1 29.0 PACKAGING RESOURCE #1 Pick: Packing Kit 30.0 D22301 Mounting Lug Total: 4.0000 Each(s)/Unit 4.0000 Each(s) Comment: Pick: Packing Kit

DescriptionBatch

Qty Part Number

D2230-1